

# Work Order ID 64217

Tuesday, November 30, 2010 12:32:43 PM



Page 1

Item ID: D3828-1KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel Lower, LH

Stop



Start Date: 11/30/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3828

A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*XP*

*Dh*

*10/12/16*

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 KYDEX

Temp: *150*

Time IN: *4:30*

*10/12/15*

Time OUT: *7:00*

*10/12/16*

*3*

*BB 10/12/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64217

Tuesday, November 30, 2010 12:32:43 PM



Page 2

Item ID: D3828-1K1V

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA052 using tool DT9228  
Dwg Rev: A  
Folio Rev: \_\_\_\_\_

3 12/12/16

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

3 12/12/16

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

x3 10/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64217**

Tuesday, November 30, 2010 12:32:44 PM

Page 3

Item ID: D3828-1KIV

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

3

BB  
10/12/21

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

3

BB  
10/12/21

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8.10/12/23

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64217**

Tuesday, November 30, 2010 12:32:44 PM

Page 4

Item ID: D3828-1KIV

Accept

Revision ID:

Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010 Start Qty: 3.00

Required Date: 12/14/2010 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00



Packaging

Memo

PPP64220

0.00

Packaging

180 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/6/03 (3)

OK 11/01/04

11/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Tuesday, November 30, 2010 12:32:42 PM

Work Order ID: 64217



Parent Item: D3828-1KIV



Parent Item Name: Vertical Tunnel Lower, LH

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-  
62015

Purchased

No

100

sf

402.9050

2.7083

2.625

7.875



6185 KYDEX .080"

DL  
10/12/14LocationLoc QtyLoc Code

therm

402.905

109703

402.905

8.12509 DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

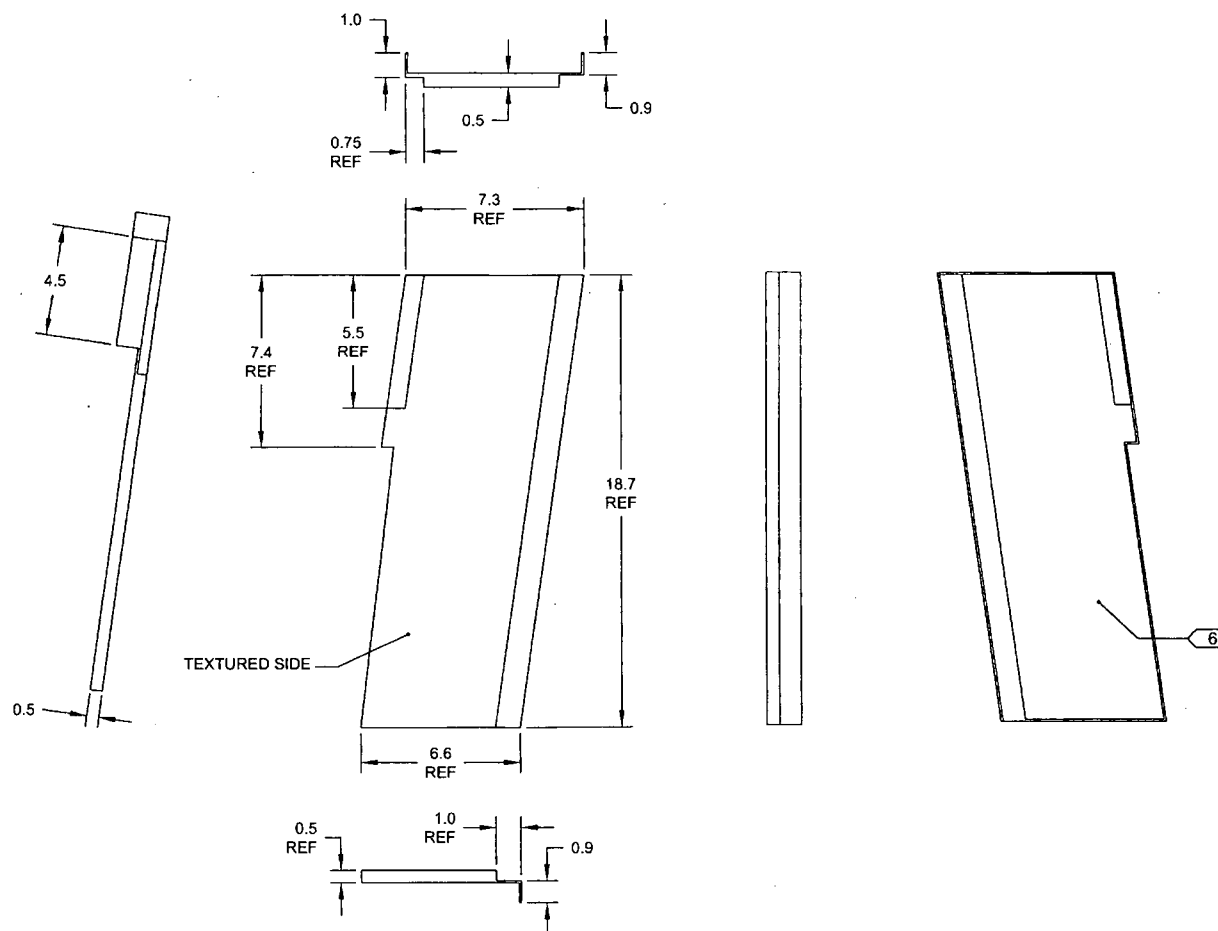
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

664217



D3828-1 VERTICAL TUNNEL, LOWER L/H

## NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9228 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

REV.	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.12		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3828  
REV. A  
SHEET 1 OF 2  
TITLE VERTICAL TUNNEL (206 L/L1/L3/L4)  
SCALE NTS

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**RELEASED**  
09/06/25/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

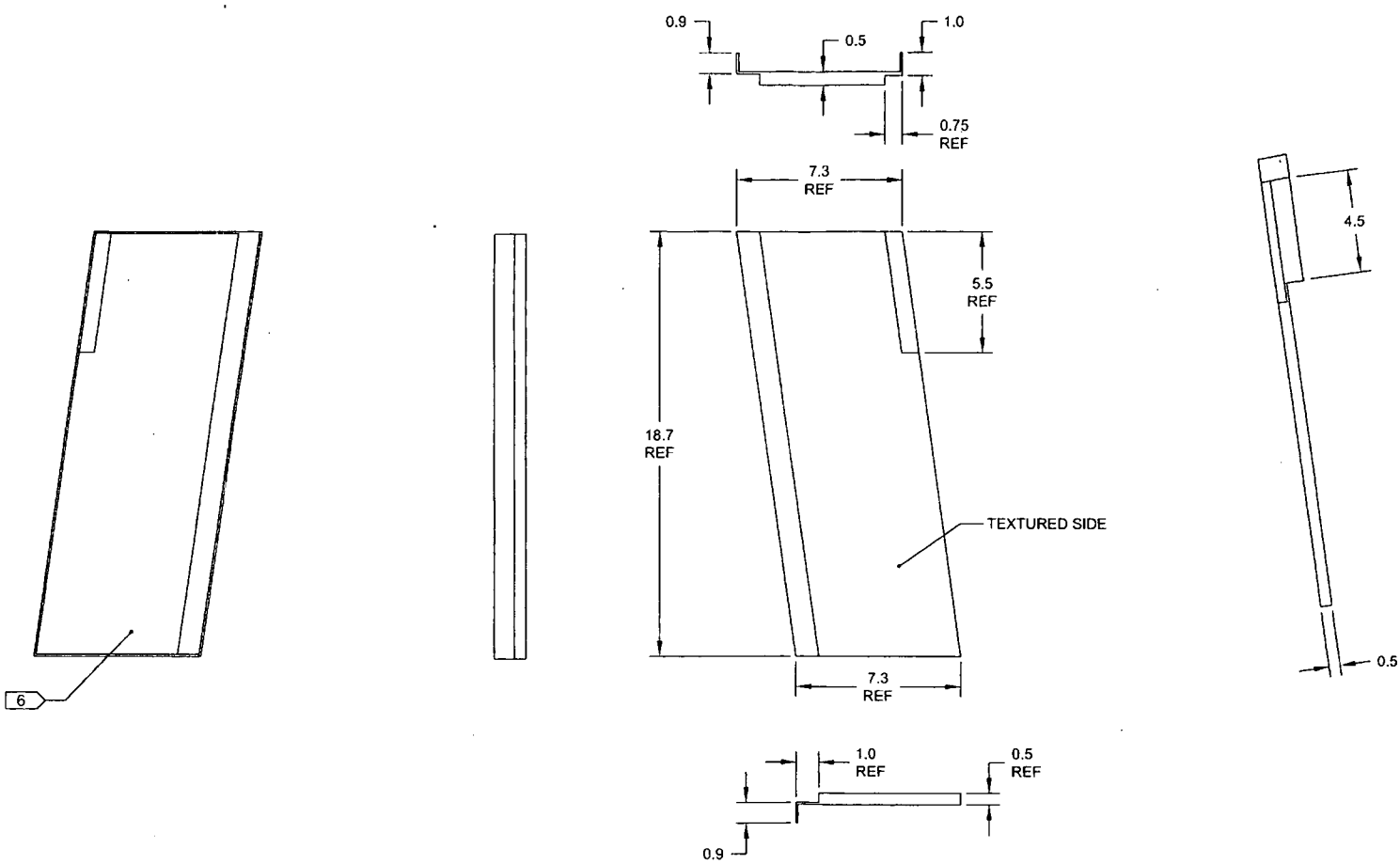
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

644217



D3828-2 VERTICAL TUNNEL, LOWER R/H

RELEASED  
9/16/25

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 0.6 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9229 PER DART QSI 022. TRIM PER MOLD.
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. REV. A D3828 SHEET 2 OF 2 TITLE SCALE VERTICAL TUNNEL (206 L/L1/L3/L4) NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.06.12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order: 64217
Description: VERTICAL TUNNEL LOWER L/H	Part Number: D3828-164
Inspection Dwg: D3828 Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 10/12/21

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.7	REF	18.7				
7.3	REF	7.375				
4.5	REF	4.5				
1.0	±.100	1.1				
.9	±.100	1.0				
.6	±.100	.6				
.050	M.I.N	.065				

Measured by: JB

Date: 10/12/21

Audited by: J

Date: 10/12/23

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14